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REPORT

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INFORMATION FROM
FOREIGN DOCUMENTS OR RADIO BROADCASTS

CD NO.

COUNTRY Rumania

SUBJECT Economics - Brick production

HOW
PUBLISHED Daily newspaper

WHERE
PUBLISHED Bucharest

DATE
PUBLISHED 4 Aug 1951

LANGUAGE Rumanian

DATE OF
INFORMATION 1951

DATE DIST. 19 Sep 1951

NO. OF PAGES 2

SUPPLEMENT TO
REPORT NO.

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WORKERS MODIFY DUVANOV METHOD OF MAKING BRICKS
TO INCREASE KILN PRODUCTION

The workers of Krasnodar have modified the Duvanov method of rapid firing bricks. By use of the new technique, 1,400-1,500 bricks per month per cubic meter of kiln space can be produced, even with clay having a moisture content of 15-17 percent.

Zinoviev, a young skilled worker, proposed that the 18-chamber kiln be converted to a rapid firing system with two fires. Production then rose from 680-790 bricks per month per cubic meter of kiln space to 1,360-1,400, with 15 to 17 percent moisture content, and there was an improvement in quality. Even higher totals are expected eventually.

The old kilns were modified for the application of the new method. Each chamber was transformed into two smaller chambers, each having a separate vent for the introduction of combustion gases. This was done by doubling the number of draft flues, a supplementary flue being made in each main flue. To each supplementary flue was connected a transversal smoke duct.

This adaptation of the Duvanov method makes more efficient use of heat and combustion gases. Zinoviev eliminated the grate, casting the fuel directly against the base. This has permitted an increase in the number of bricks per cubic meter (265 bricks). An arrangement of bricks closer than called for by the Duvanov method has not influenced the temperature of the bricks by more than 30-50 degrees. The moisture content of the raw bricks placed in the kiln was between 15 and 17 percent. Drier bricks are used for tiers three to four rows high.

Zinoviev performed experiments with bricks of varying moisture content. He placed two charges in the kiln, one of raw bricks taken directly from the press, the other of bricks that had been held in the drying oven for 24 hours. The first charge was arranged in nine rows, the other in two rows of ten bricks each. The lower charge was composed of the raw bricks having a moisture content of 15-17 percent. Both charges were fired by the rapid firing method. The first was entirely faulty, the second yielded bricks of exceptional quality.

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From the above it can be seen that the circular kiln can be used for firing bricks with a moisture content of 16-18 percent, assuring production of between 1,300 and 1,400 bricks per cubic meter per month. The kilns with 16-18 chambers heated by two fires do not necessitate a radical change from the old style.

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